

Work Order ID 75328

October-20-11 2:56:54 PM

75328

Page 1

Item ID: D2721-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206B Step Assembly

Start Date: 20/10/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/10/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2721	Rev C

100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	Cut D2721-1 using D2622 extrusion as per Dwg D2721 Debur and bevel ends for welding								

110	Large Fab	0.00							
110									
Large Fab	Memo	0.00							
Large Fab	Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT followed by Jig DT								
	A/R AL Rod Batch: <u>114514</u> <u>118735</u>								
	Grind end cap welds flush								

75328.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2721-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206B Step Assembly
 Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120						2	0		BE 11/10/28
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130						72			
QC	Memo	0.00				LH			
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

2x4 m-11/11/02
LH2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop ***NS2***

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2

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Inspect for foreign object per QSI 024								
	Weld Remaining end cap as per Dwg D2721 using Jig DT								
	Jig DT								
	A/R AL Rod Batch: <u>114514</u>								
	Grind End Cap Welds Flush								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NS1

Revision ID:

Stop

NS2

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Start Date: 20/10/2011 Start Qty: 2.00

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Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

~~QC9~~- Inspect visual per QSI004- Fusion Welds

0.00

170

QC

Quality Control

QC10

Memo

0.00

8/11/09

Pro →

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

Memo

0.00

8/11/09

190

Chemical Conversion Coat per QSI005 4.1

0.00

190

HandFinish

Hand Finishing

Memo

0.00

2X Ø M-11/11/09
LH

W/O: 75328

Perm. Chg

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/11/09	#170	change to QC inspection	DA	11.11.15			S 11/11/09

 Part No: D2721-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Powdercoat Powder Coating M118439	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 2:00 OVEN TEMPERATURE: 320 FINISH TIME: 2:30	0.00 0.00							2X Ø M / 11/11/09
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							2 BL 11-11-10
220 *220* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 118988 Memo	0.00 0.00							2 BL 11-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
						264	4	11/11/10	COUNTED & MEASURED
240 *240* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
									11/11/14 (2)
250 *250* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
									11/11/15 (2)

11/11/14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75328

75328

Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing
walk DD 10.02.24 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

108.1200

1

2

D2622-120C

Step Extrusion

**

11.10.26

Location

Loc Qty

Loc Code

HALL

98.42

64409

6

68293

0.5

72131

91.92

2

WA

9.7

46910

2

66970

7.7

D2734

Manufactured No

110

Each

68.0000

1

2

D2734

Step End Plate

**

11.10.26

Location

Loc Qty

Loc Code

WA

68

73196

8

73416

60

2

D3461-1

Manufactured No

110

Each

48.0000

1

2

D3461-1

Mounting Plate

**

11.10.26

Location

Loc Qty

Loc Code

WA017

48

41600

2

58756

46

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75328

75328

Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 20/10/2011

Required Date: 02/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3461-3 Manufactured No

110 Each 5.0000 1 2

D3461-3

Mounting Plate

**

11.10.26

Location

Loc Qty

Loc Code

WA017

5

41601

5

D3461-5 Manufactured No

110 Each 21.0000 1 2

D3461-5

Mounting Plate

**

11.10.26

Location

Loc Qty

Loc Code

WA017

21

33862

21

D3461-7 Manufactured No

110 Each 23.0000 1 2

D3461-7

Mounting Plate

**

11.10.26

Location

Loc Qty

Loc Code

WA017

23

33863

23

D2734 Manufactured No

160 Each 68.0000 1 2

D2734

Step End Plate

**

11.11.03

Location

Loc Qty

Loc Code

WA

68

73196

8

73416

60

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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